Dart Aerospace Ltd.

Date: Monday, 1/14/2008 2:29:08 PM
User: Kim Johnston

5

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 36716		
Estimate Number	: 10022		
P.O. Number	:	Part Number	: D205634011
This Issue	: 1/14/2008 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 36477	Material	:
Written By	:	Due Date	: 1/31/2008 Qty: 1 Um: Each
Checked & Approved By	: KJ 08 01 15		
Comment	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:

Seq. #	Machine Or Operation	Description
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPP D205-634-011 CHG005

KJ 08.01.22 — 08/02/08

Seq. #	Machine Or Operation	Description
2.0	36716A	SKID TUBE ASSEMBLY

Comment: Sub-Component SKID TUBE ASSEMBLY
D205-634-041 B B36716A

AS 08/02/08

Seq. #	Machine Or Operation	Description
3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

Seq. #	Machine Or Operation	Description
4.0	K10003	D205-634-011 Saddle Kit

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	36308

AS 08/02/08

Seq. #	Machine Or Operation	Description
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

08/2/08

Seq. #	Machine Or Operation	Description
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-011
Location: Rev J.

AS 08/02/08

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes / No (circled: No) **DQA:** [illegible] **Date:** 09/02/12

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:29:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKIDTUBE ASSEMBLY

Job Number: 36716 **Part Number:** D205634011

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

36716 A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:29:35 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36716A
Estimate Number : 10023
P.O. Number :
This Issue : 1/14/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / /
Type : LANDING GEAR
Previous Run : 36477A
Written By :
Checked & Approved By : 08 01 14
Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC
Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Drawing Name : SKID TUBE ASSEMBLY
Part Number : D205634041
Drawing Number : D2580 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 1/31/2008 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002 N/A

2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B29602 a.m 08.01.15

3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	36803 SL 8-1-17

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage a.m 08.01.16

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends a.m 08.01.16

3-Acid etch and Alodine tube per QSI 005 4.1 a.m 08.01.16

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 36716A **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION NR 8-1-16

Seq. #:	Machine Or Operation:	Description :
6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid) a.m 08.01.16

2-Open holes to 0.500" as per Dwg D2580without cutting fluid a.m 08.01.16

3-Countersink holes as per Dwg D2580without cutting fluid a.m 08.01.16

4-Deburr and blow out all chips from inside of tube a.m 08.01.16

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R		Sikaflex-291	105469

SL 8-1-17

Sikaflex expire date: 8-30-1

Start Time: 1:00 Date: 8-1-17

Fin Time: 1:00 Date: 8-1-21

Seq. #:	Machine Or Operation:	Description :
7.0	BENDING	BENDING MACHINE

Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580 EL/TR 8-1-21

Seq. #:	Machine Or Operation:	Description :
8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends a.m 08.01.22

2-Prepare tube for welding, remove alodine as required. a.m 08.01.22

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36716A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP BF 08-01-22

Seq. #:	Machine Or Operation:	Description :
10.0	D25763	Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B33321-1 BF 08/01/31

Seq. #:	Machine Or Operation:	Description :
11.0	D2579	Crossbolt Spacer

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B36326 BF 08-01-22

Seq. #:	Machine Or Operation:	Description :
12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004.
A/R Aluminum Rod M106390 BE 08/01/31

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod M106390 BF 08-01-22

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

7-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

SL 8-1-24

Dart Aerospace Ltd

W/O:		**WORK ORDER CHANGES**					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:		**WORK ORDER NON-CONFORMANCE (NCR)**						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:29:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36716A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 08-02-01
14.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	08/02/01
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Pressure wash as per QSI 005	08·02-05
16.0	POWDER COATING	POWDER COATING M 106379 (1X)
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	08/02/05
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION (1).
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	BK 08-02-05
18.0	D2855	Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cap Batch: B 35665	BK
19.0	AN35A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt Batch: M 10088	BK
20.0	AN960JD10L	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer Batch: M 104885	

BK 08-02-05 (1).

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:29:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36716A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
21.0	ALS71032130 (ALS41032130)	Insert (2008/2/11)
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) Insert Batch: M 105729	BL
22.0	AN3C4A	BOLT
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) BOLT Batch: M106574	BL
23.0	AN960C10L	washer
	Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s) washer Batch: M 107008	BL
24.0	D356613	GASKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B32744	BL
25.0	D35665	GASKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) GASKET Batch: B36526	BL
26.0	D35661	GASKET
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) GASKET Batch: B 36934	BL
27.0	D356413	WEARSHOE
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) WEARSHOE Batch: B36337	BL

BL 08-02-05

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:29:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 36716A **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
28.0	D356411	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B34805 BR

29.0	D35649	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B36637 BR

30.0	D35645	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: 36338 BR

31.0	D25943	O-Ring

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
O-Ring
Batch: B27168 BR

32.0	D25941	Plug

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Plug
Batch: B34790 BR.

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M105585
Sikaflex expire date: 08.07

BR 08-02-05 ①.

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

BR 08-02-05 ①.

Form: process

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes ~~No~~ (circled) **DQA:** D **Date:** 08/02/12

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:29:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SKID TUBE ASSEMBLY

Job Number: 36716A
Part Number: D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
	4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 M105585 Sikaflex expire date: 08-07 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: M166894	08-02-05 08/02/06
34.0	QC5	INSPECT WORK TO CURRENT STEP 08/2/07

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

Seq. #:	Machine Or Operation:	Description :
35.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-634-041
Location:___________
PPP Rev: 36716 08/02/08

Seq. #:	Machine Or Operation:	Description :
36.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 08/02/12

Job Completion 2008/2/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS

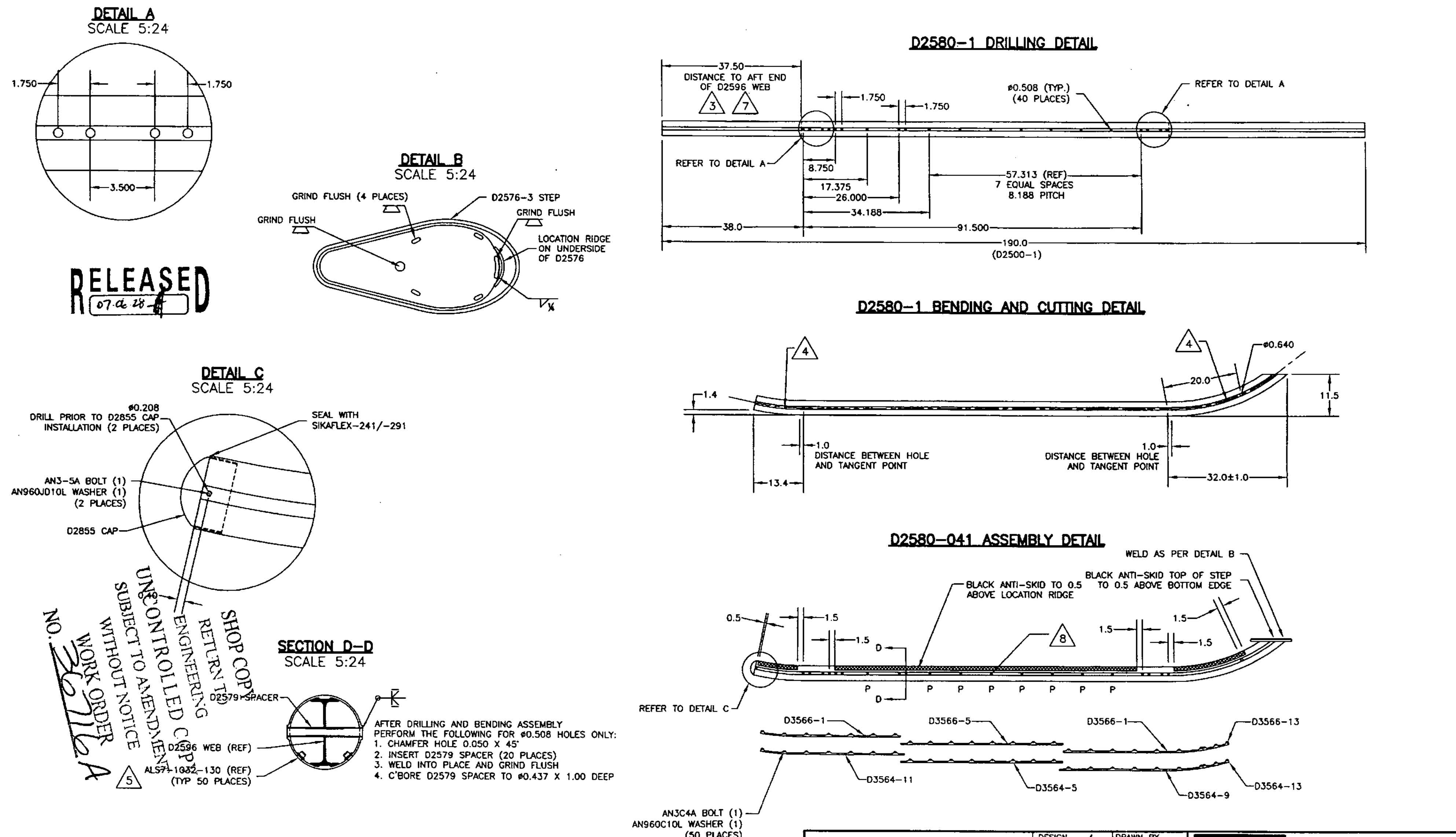
A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED 07.06.28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

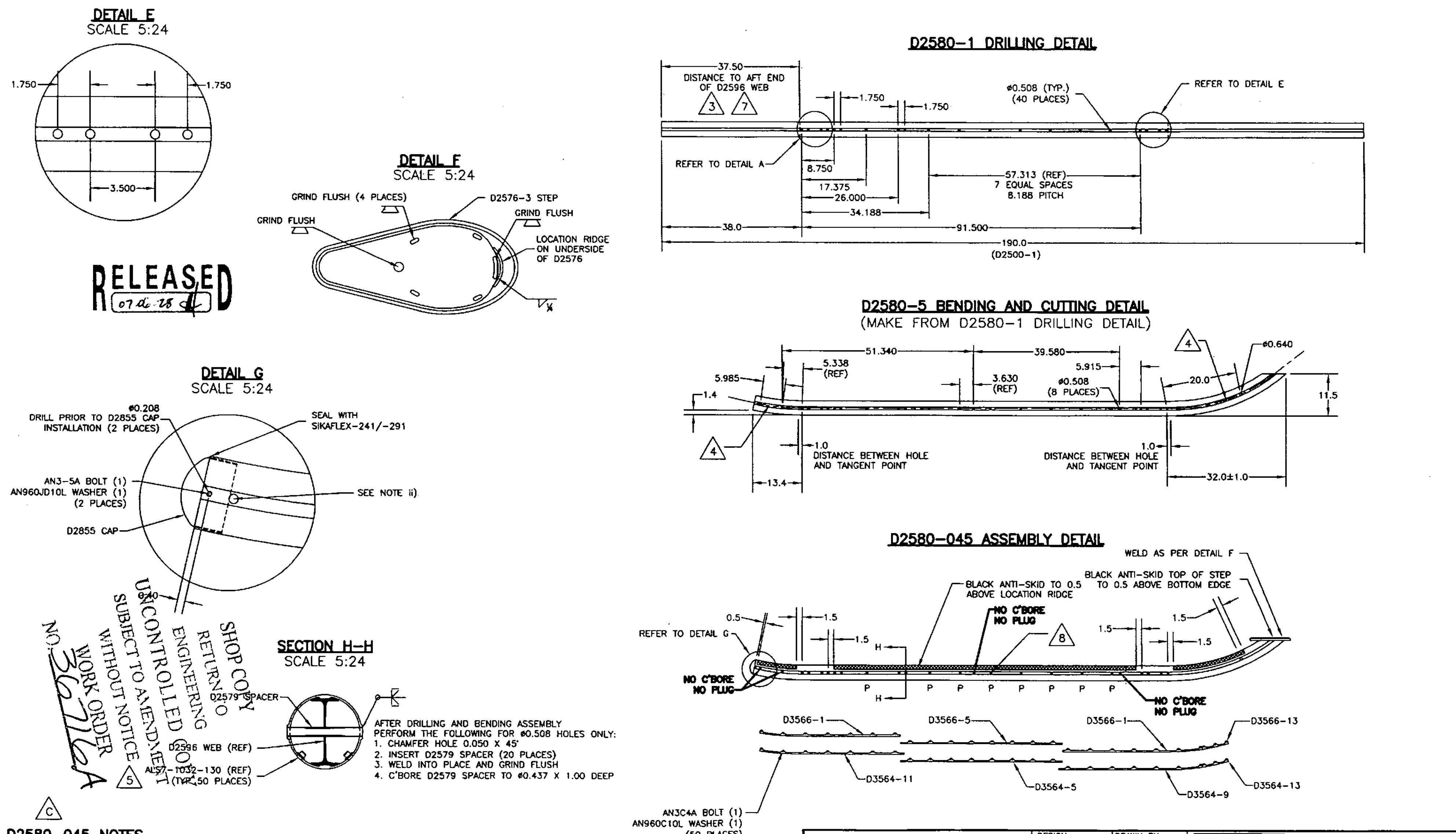
1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   SEE NOTES ON
   PAGE 2 FOR D2580-041 AND
   PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).



D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 2 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24



D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
RH	RH		
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

NO. 141

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay E.
Joint Welding Procedure GTAW
Part number and Job number D 305 634 011 / B302214

TEST WELDS REQUIRED

BASE METAL Aluminium
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS tig
Single Weld [✓] **Double Weld** [ ]
Backing YES [ ] NO [✓]

	Position			**Vertical** Down [ ] Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [✓]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into ____________ Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-02-01 **Qualifier** [signature]